

Work Order ID 91162

October-03-12 9:08:19 AM

91162

Page 1

Item ID: D2680-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Nut Plate

Start Date: 03/10/2012 Start Qty: 80.00

80

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-10-03 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2680	Rev B1								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2680 Dwg Rev: <u>B1</u> Prog Rev: <u>B1</u> 2-								
1010.063	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

(90)

FB12-10-11

(90)

FB12-10-11

90
cont

Smb
12/10/12

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					90x			12/11/13
Small Fab	Memo	0.00							
Small Fab	1- Deburr 2-C'sink as per Dwg D2680								
140		0.00							
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				90			
Quality Control						cont			
150		0.00							
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:45								
	FINISH TIME: 11:15								

M122878

4000 F

11:15

90X ✓ 12/11/14

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				90x	f	11/11/12	
170 *170* Small Fab Small Fab	Small Fab Memo Install Nut Plate as per Dwg D2680	0.00 0.00				90x			12/11/20
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				90			

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Identify as per dwg & Stock Location: 014

0.00

190

Packaging

Memo

0.00

Packaging

Ca 12/4/12 (90)

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/11/2012 MFME
12-11-29

Picklist Print

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Page 1

Work Order ID: 91162

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Parent Item: D2680-041

D2680-041

Parent Item Name: Nut Plate

Start Date: 03/10/2012

Required Date: 12/11/2012

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP: D04.10.01Added Steps 2-4, 7-8KJ/JLM
IPP Rev:E Now on WaterJet 06-10-12 JLM
IPP rev F QC5 after c'sink 07.07.05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21069L4 *MS21069L4* Nutplate		Purchased	No			110	Each	91.0000	1	80			
				<u>Location</u>				<u>Loc Qty</u>					
				ST302				41					
					119042			41					
				ST303				50					
					120498			50					
M1010S16GA *M1010S16GA* 1010/1025 sheet 16GA		Purchased	No			170	sf	116.3000	0.0131	1.103158			
				<u>Location</u>				<u>Loc Qty</u>					
				MAT				116.3					
					111410			0					
					122455			116.3					
MS20426AD3-3 *MS20426AD3-3* Rivet		Purchased	No			170	Each	13,664.75	2	160			
				<u>Location</u>				<u>Loc Qty</u>					
				ST316				1470					
					119109			282					
					121011			771					
					19099			417					
				ST334				12194.75					
					122814			12194.75					

Handwritten signature and date 12/11/20

Handwritten number 1123265 (900)

Handwritten date 12-10-11

Handwritten number 90

Handwritten number 122455

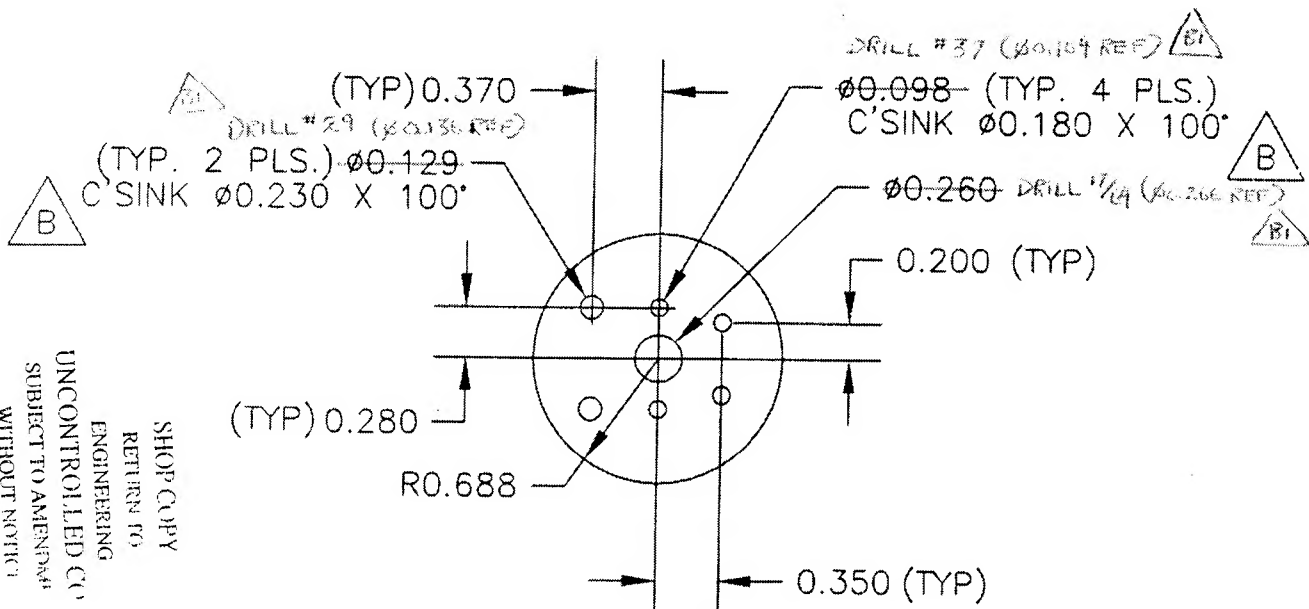
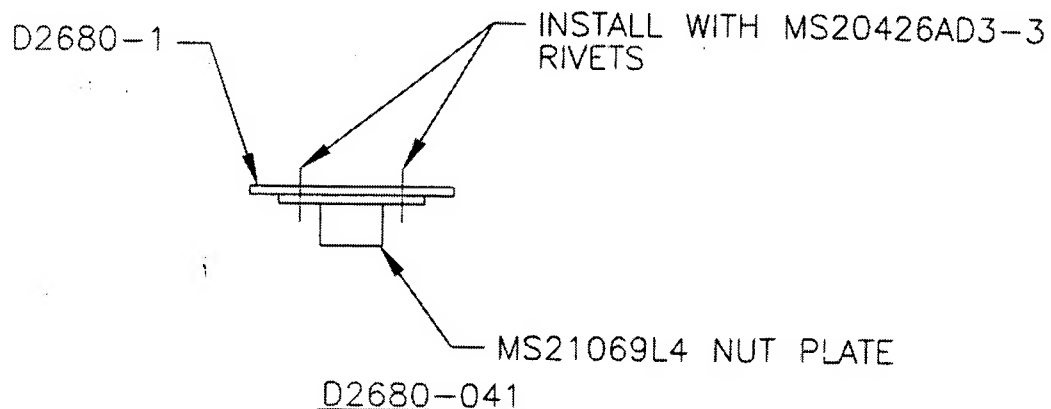
Handwritten signature and date 12/11/20

Handwritten number 180



DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED P	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14		TITLE NUT PLATE	SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
B1	99.11.09	CHANGE HOLES & FINISH	

RELEASED
18.12.14 DS



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)
CAD PLATE PRIOR TO INSTALLATION OF MS21069L4
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
POWDER COAT WHITE (4.35.2) PER DART QSI 005 4.3
D2680-1